

Date: Tuesday, 8/28/2007 3:23:23 PM
 User: Kim Johnston

Process Sheet

split into
 SB 07/11/13

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ARM
 Job Number : 34322 -1
 Estimate Number : 12974
 P.O. Number : *NA*
 This Issue : 8/28/2007 S.O. No. : *NA*
 Prsht Rev. : NC
 First Issue : *NA* Type : SMALL /MED FAB
 Previous Run : *NA*
 Part Number : D36463
 Drawing Number : D3646 REV.A
 Project Number : N/A
 Drawing Revision : A
 Material : *NA*
 Due Date : 9/28/2007 Qty: 10 Um: Each
 Written By : *ADW.08.28*
 Checked & Approved By : *ADW.08.28*
 Comment : Est Rev. A new issue 07.07.25 EC verified by:JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TR0500W035 304 RD Tube .500 x .035W



Comment: Qty.: 3.0555 f(s)/Unit Total : 30.5550 f(s) *31" 36 5/8" 39.100*
 Material: 304/316 Seamless SS tubing, 1/2" O.D. x .035" wall(M304TR0.500W.035)

Batch: *M104880 1x**M106015 (9)**SB**07/11/14**(9)*

2.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Punch to length as per Dwg D3646 & template *DT8959**SB**07/11/14**(1)*

3.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr *→ 07/11/14 (9)*

2- Bend as per dwg D3646

*FF 07-11-21**PTO**8*

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 07/11/22 (x9)
caly

5.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M-1 07/11/22
(8x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3646-3 PAR #: NA Fault Category: Prod / FAB. ASS. mfg & SNAI NCR: Yes No DQA: D Date: 07/11/26
 QA: N/C Closed: H Date: 07.11.27

NCR: <u>34322</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/11/21	3	1 ARM Punched to short Human error RC. Human error	<u>ASIAN</u>	cut Peace up. No replacement	FF 07/11/21	<u>ASIAN</u>	<u>ASIAN</u>	<u>07/11/22</u>

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 34322

Part Number: D36463

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD 07/11/22 (7)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 228

11/1/26 54 (8x)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(8) 07/11/26

Job Completion



U 07/11/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

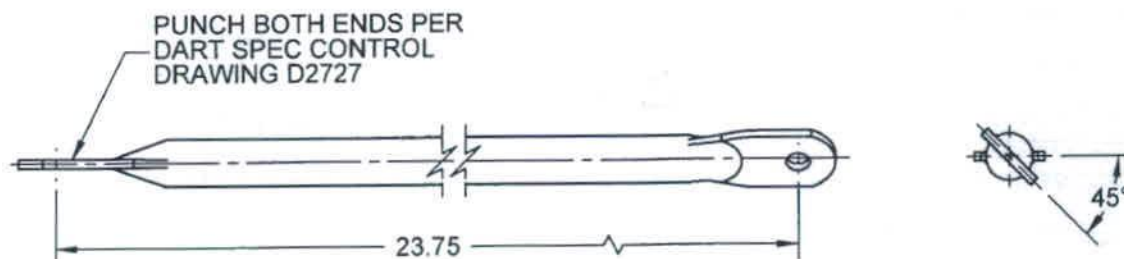
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3646	REV. A SHEET 1 OF 2
DATE 07.06.06		TITLE ARM	SCALE 1:2
REV A	DATE 07.06.06	DESCRIPTION NEW ISSUE	

RELEASED07.07.11 *[Signature]***D3646-1 ARM****NOTES:**

- 1) MAKE PER TEMPLATE DT8958
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
(REF. DART SPEC. M304TR0.500W.035)
- 3) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005.4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

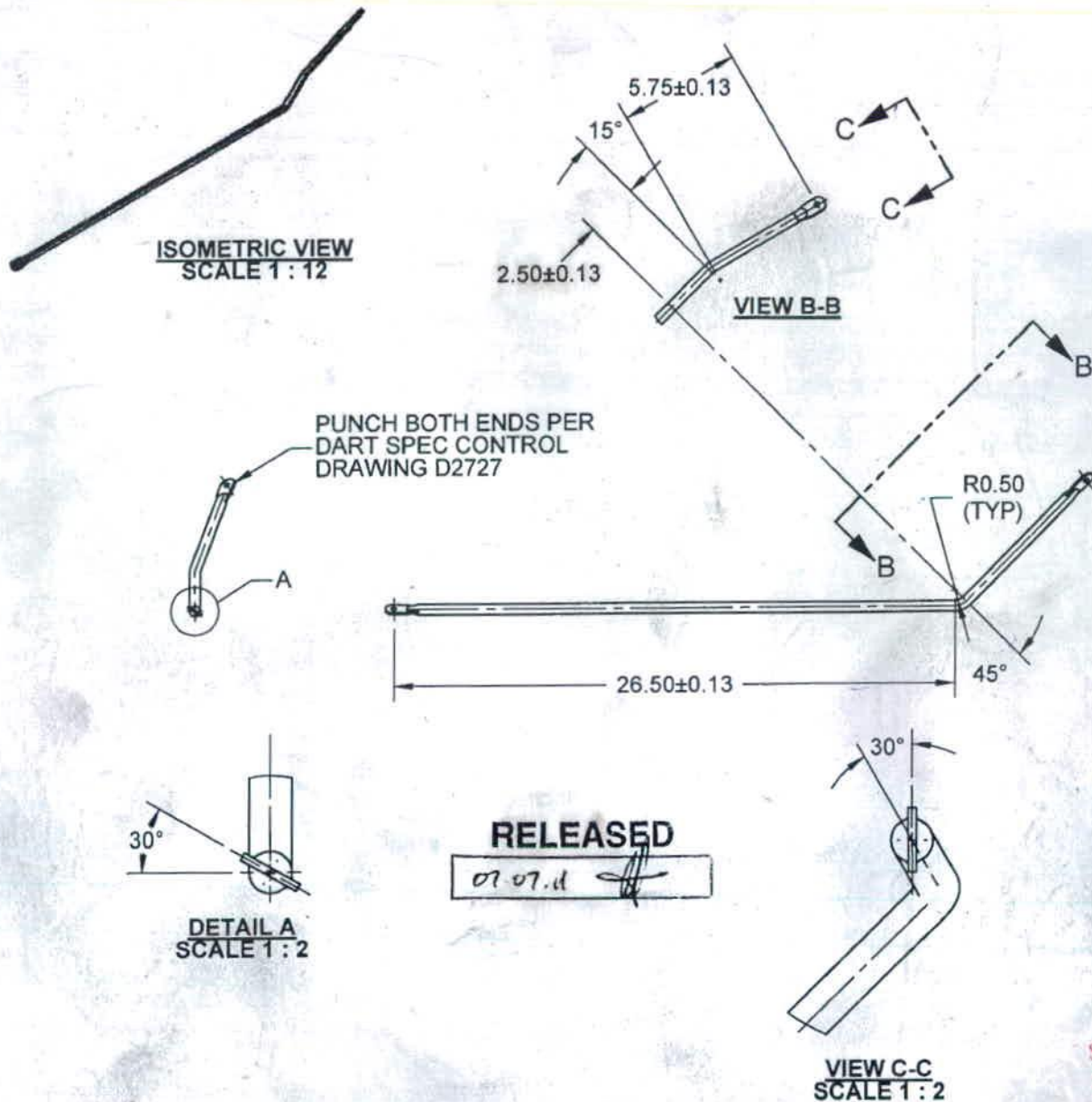
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DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3646	REV. A SHEET 2 OF 2
DATE 07.06.06		TITLE ARM	SCALE 1:8

**D3646-3 ARM****NOTES:**

- 1) MAKE PER TEMPLATE DT8959
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
(REF. DART SPEC. M304TR0.500W.035)
- 3) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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